

5/22

DART AEROSPACE LTD	Work Order:	23452
Description: Step Weldment Assembly	Part Number:	D3438-042
Dwg: D3438 Rev. A	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	PK	05.05.30	4																				
2	WA	Cut D2244 to 79.63" at 34° as per Dwg D3438 Batch: <u>B21592</u>	PK	05.05.30	4																				
3	WA	Deburr ends	PK	05.05.30	4																				
4	WA	Inspect for foreign objects as per QSI 024	PK	05.05.30	4																				
5	WA	Weld using DT8343 as per Dwg D3438 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2561</td><td>Lug Plate</td><td><u>B23179</u></td></tr><tr><td>2</td><td>D2564</td><td>Mounting Angle</td><td><u>B23452</u></td></tr><tr><td>2</td><td>D2673-34</td><td>End Cap</td><td><u>B23231</u></td></tr><tr><td>A/R</td><td>N/A</td><td>Aluminum Rod</td><td><u>M12552</u></td></tr></table>	Qty	Part Number	Description	Batch	2	D2561	Lug Plate	<u>B23179</u>	2	D2564	Mounting Angle	<u>B23452</u>	2	D2673-34	End Cap	<u>B23231</u>	A/R	N/A	Aluminum Rod	<u>M12552</u>	PK	05.05.30	4
Qty	Part Number	Description	Batch																						
2	D2561	Lug Plate	<u>B23179</u>																						
2	D2564	Mounting Angle	<u>B23452</u>																						
2	D2673-34	End Cap	<u>B23231</u>																						
A/R	N/A	Aluminum Rod	<u>M12552</u>																						
6	WA	Grind	PK	05.05.30	4																				
7	QC9/5	Inspect welding and work to Step 6	PK	05.05.31	4																				
8	FP	Acid etch and Alodine as per QSI 005 4.1	MM	05.05.31	4																				
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	MM	05.05.31	4																				
10	FP	Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs	M	05.05.31	4																				
11	QC3	Inspect Powder Coat and Wing Walk	CL	05/06/01	4																				
12	ST	Identify and Stock	CL	05/06/01	4																				
13	AC	Cost / part: <u>95.50</u>	SG	05.05.08	4																				
14	DC	Close W/O <u>95.50</u> Inspect Level 21	PK	05.06.01	4																				

Rev	Date	Change	Revised By	Approved
A	05.05.18	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 05.05.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

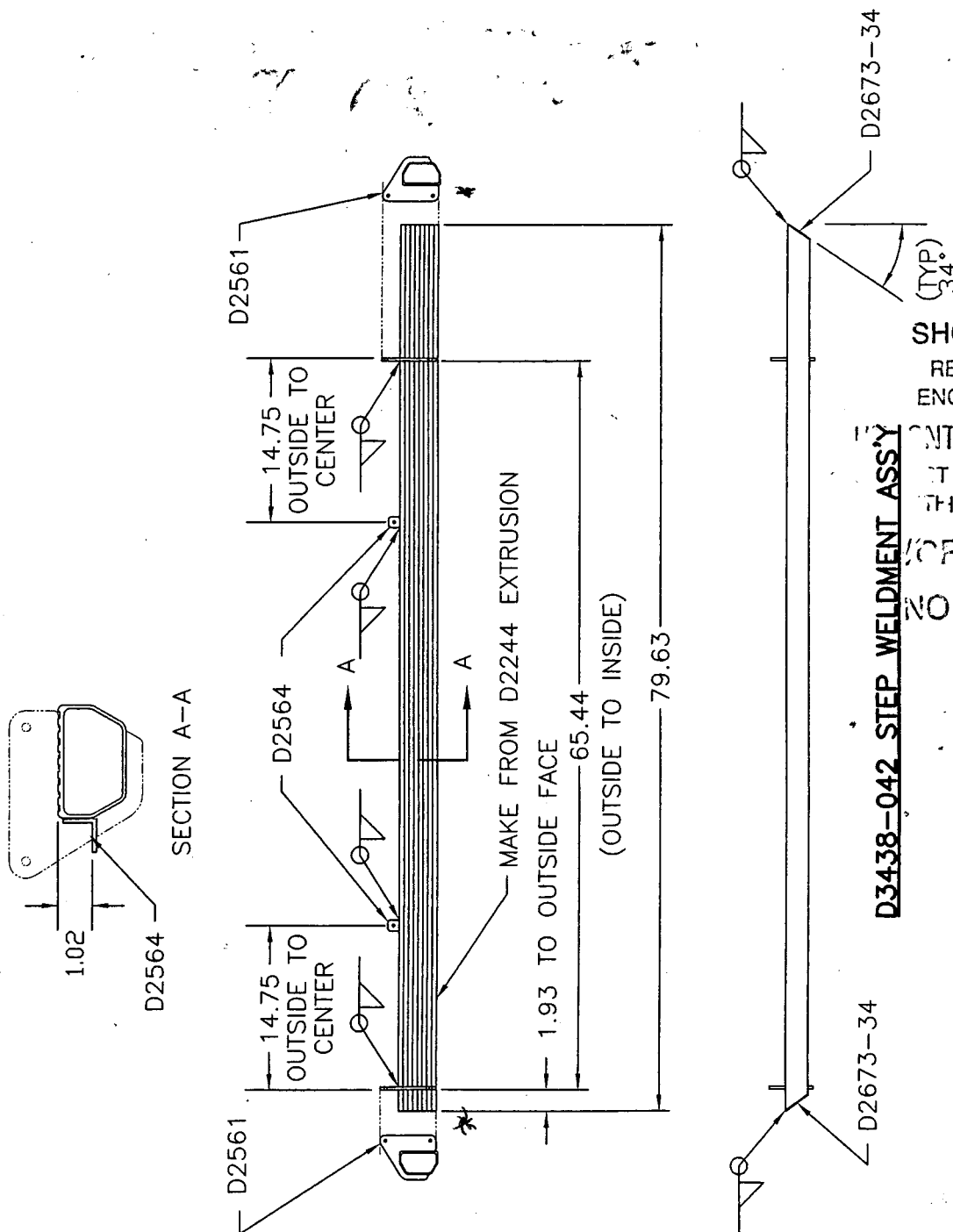
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09	TITLE STEP WELDMENT ASSEMBLY		SCALE 1:1
A	05.05.09	NEW ISSUE	



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WITHOUT NOTICE

WORK ORDER
NO. 23452

NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 30, 2005
10:29 am

Work Order No : 0023452
Project Name : D3438-042
Project For : WK522
Work Order Type : Main
Main WO Number :
House Part Number : D3438-042
Description : Step Weldment Assembly
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 05-30-05
Est Finish Date : 06-02-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00